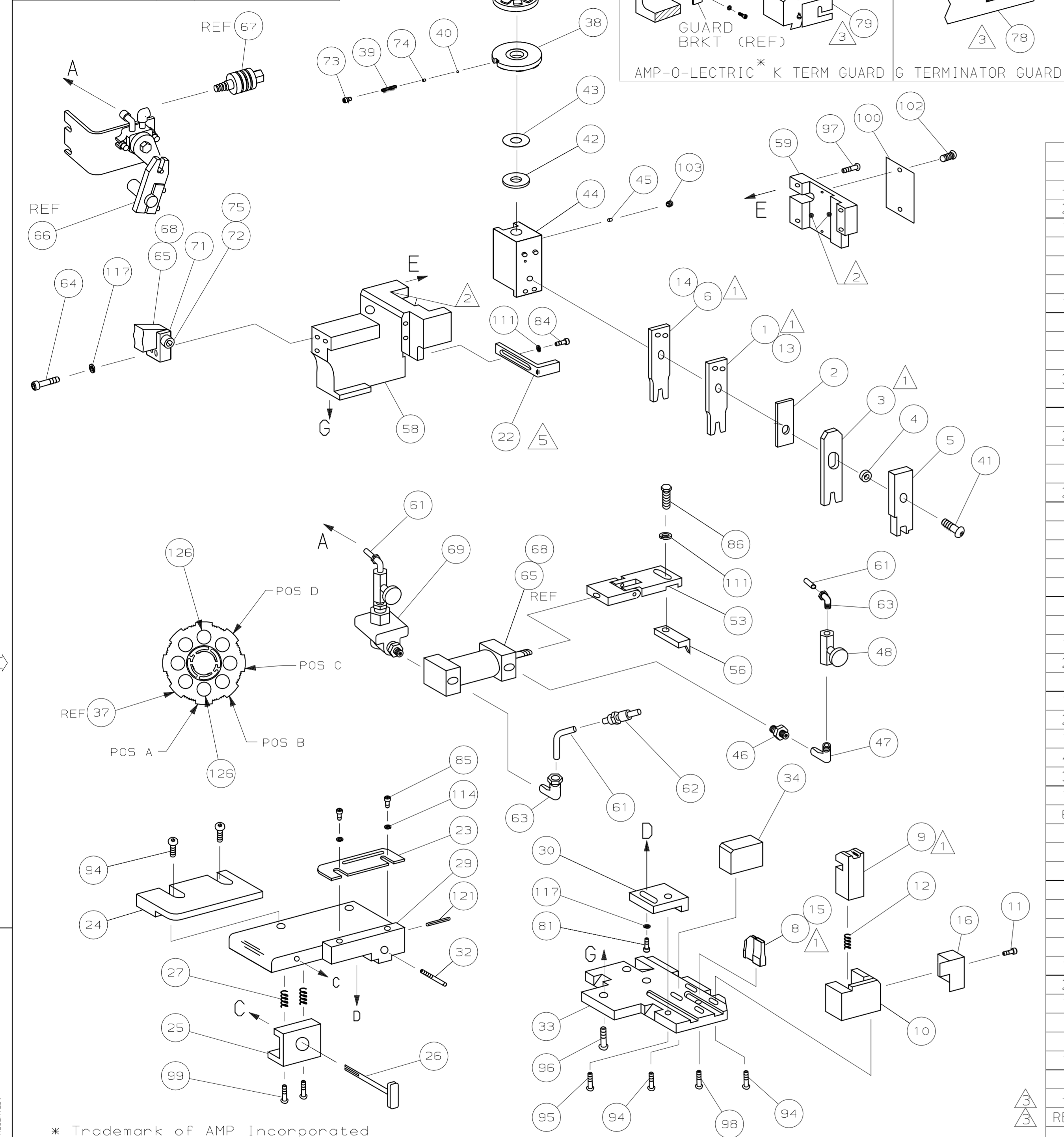


PART NUMBER	REV	FIRST USED
680078-1	P	854400-1
680078-2	N	565435-5
680078-3	P	354500-1
680078-4	N	565435-5
680078-5	P	854400-1



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 SEE DRAWING FOR COMPONENTS
- 5 LOCATE ITEM 22 BETWEEN ITEM 1 & ITEM 3.
- 6 FOR USE IN PRINTED CIRCUIT BOARD WITH A ϕ .125 HOLE FOR #12 WIRE, ϕ .145 HOLE FOR #10 WIRE.

7 CRIMP HEIGHT CAN NOT BE MEASURED FOR INSULATION ON #10 WIRE SINCE INS BARREL WILL NOT COMPLETELY SURROUND IT.

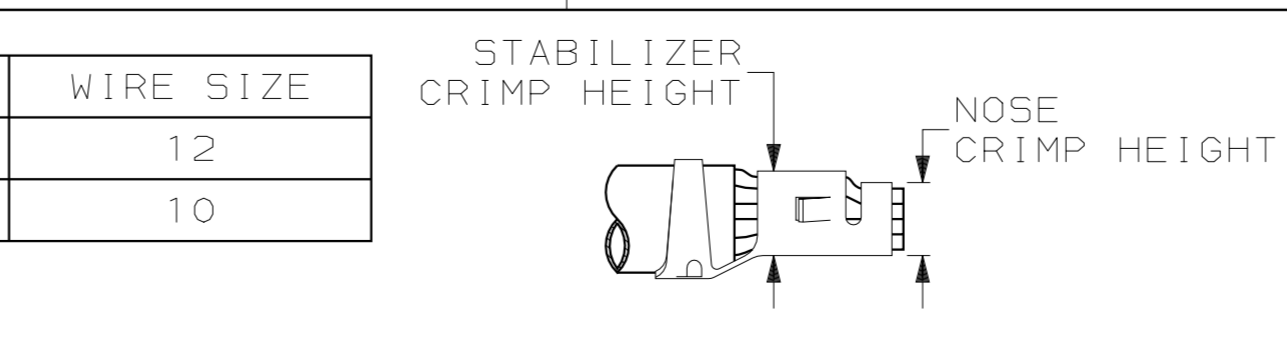
8 CRIMP HEIGHT TO BE MEASURED OVER CENTER BARREL (STABILIZER). NOSE CRIMP HEIGHT TO BE .095 \pm .002 FOR 12 GA WIRE .108 \pm .002 FOR 10 GA WIRE. SEE CHART BELOW

APPLICATOR PN	CRIMP SIZE	NOSE CRIMP HEIGHT	WIRE SIZE
680078-1, -2 & -3	.110 - F	.095	12
680078-4 & -5	.140 - F	.108	10

9 NO BELLMOUTH PERMISSIBLE.

680078				680078			
CRIMPING DATA FOR -1, -2 & -3				CRIMPING DATA FOR -4 & -5			
PAD LETTER	STABILIZER CRIMP HEIGHT	WIRE SIZE		PAD LETTER	STABILIZER CRIMP HEIGHT	WIRE SIZE	
A	.110 \pm .002	12		A	.110 \pm .002	10	
B	NOT USED			B	NOT USED		
C	NOT USED			C	NOT USED		
D	NOT USED			D	NOT USED		
CRIMP	SIZE	TYPE	RANGE	CRIMP	SIZE	TYPE	RANGE
NOSE	.110	F	12	NOSE	.140	F	10
STABILIZER	.110	0	12	STABILIZER	.140	0	10
INSULATION	.210	0	.200 MAX	INSULATION	.210	0	.200 MAX

QTY	REQD	PER	ASSY	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	PARTS LIST
1	1	1	1	1	21009-2 SCR, SKT SET (1/4-20x.25 LW) RAM
2	2	2	2	2	21017-2 SCR, DRIVE (#2x.19) ID PLATE
1	1	1	1	1	461264-1 PLATE, IDENTIFICATION
2	2	2	2	2	3-21002-0 SCR, BHC (10-32x.88) DRAG
1	1	1	1	1	22733-8 SCR, BHC (8-32x.38 LW) ANVIL
4	4	4	4	4	2-21002-9 SCR, BHC (10-32x.75) CAP
3	3	3	3	3	2-22733-8 SCR, BHC (1/4-20x.62) HSG
1	1	1	1	1	2-21002-7 SCR, BHC (10-32x.50) SG ADJ BLK
6	6	6	6	6	2-21002-2 SCR, BHC (8-32x.50) SHEAR
1	1	1	1	1	2-22603-1 SCR, HEX HD (8-32x.38) FEED FINGER
2	2	2	2	2	1-21000-3 SCR, SHC (4-40x.25) F ST GUIDE
1	1	1	1	1	2-21000-7 SCR, SHC (8-32x.50) STRIPPER
1	1	1	1	1	3-21000-4 SCR, SHC (10-32x.38) SG ADJ BL
-	1	-	1	-	462992-7 GUARD ASSY
REF	REF	REF	-	-	679532-1 INSERT, GUARD
1	1	1	1	1	21024-8 WASHER, LOCK (3/8)
1	1	1	1	1	690603-1 SPRING, ASSIST
1	1	1	1	1	23030-1 SCR, SHC (6-32x.25 SL) INS DISC
1	1	1	1	1	3-21001-4 SCR, SHC (3/8x.88) FEED MT
1	1	1	1	1	459610-3 MOUNT, FEED BRACKET
-5	-4	-3	-2	-1	U/M DWG SIZE



QTY	REQD	PER	ASSY	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	PARTS LIST
-	1	-	1	-	692655-5 AIR FEED VALVE ASSY
-	1	1	1	-	461065-1 AIR FEED ASSEMBLY
-	-	-	REF	-	24042-2 VALVE, SHUT OFF
-	-	-	REF	-	692655-6 AIR FEED VALVE ASSY
1	-	-	-	1	461065-4 AIR FEED ASSEMBLY
2	2	2	2	2	3-21000-9 SCR, SHC 10-32x1.00 AIR ASSY
2	-	1	-	2	980285-2 ELBOW, TUBING 1/8 NPT
2	-	1	-	2	23238-1 QUICK DISCONNECT
42.00	21.00	21.00	21.00	42.00	27319-4 TUBING, POLY-FLO ϕ .25
1	1	1	1	1	454220-1 CAP, RAM
1	1	1	1	1	454485-1 HOUSING
1	1	1	1	1	458537-2 PAWL, FEED
1	1	1	1	1	461062-1 FEED FINGER ASSY
1	-	-	-	1	23054-1 FLOW CONTROL VALVE
1	-	-	-	1	22306-1 90° ELBOW, 1/8 X 1/8
1	-	-	-	1	22304-1 NIPPLE, 1/8 X 1/8
1	1	1	1	1	690191-1 PLUG, NYLON
1	1	1	1	1	455673-5 RAM
1	1	1	1	1	690125-1 WASHER, LAMINATED
1	1	1	1	1	1-690124-0 WASHER, RAM
1	1	1	1	1	7-21002-9 BOLT, CRIMPER (5/16x1.00)
1	1	1	1	1	23241-6 BALL, STEEL
1	1	1	1	1	690170-1 SPRING, COMPRESSION
1	1	1	1	1	690142-5 DISC, INSULATION
1	1	1	1	1	354777-1 WIRE DISC, PLASTIC
1	1	1	1	1	22480-5 WASHER, SPRING
1	1	1	1	1	690212-1 POST, RAM
1	1	1	1	1	469465-1 STOP, WIRE
1	1	1	1	1	455675-1 PLATE, BASE
1	1	1	1	1	690432-3 SCREW, ADJUSTMENT
1	1	1	1	1	455689-1 BLOCK, STRIP GUIDE ADJ
1	1	1	1	1	455671-1 PLATE, STRIP GUIDE
2	2	2	2	2	1-22284-0 SPRING, DRAG
1	1	1	1	1	690546-1 LEVER, DRAG RELEASE
1	1	1	1	1	240792-1 DRAG, TERMINAL
1	1	1	1	1	6-690440-5 GUIDE, STRIP (REAR)
1	1	1	1	1	690438-1 GUIDE, STRIP (FRONT)
1	1	1	1	1	1-690472-3 STRIPPER
1	1	1	1	1	318563-1 GUARD, CHIP (FRONT)
1	1	-	-	-	2-189717-4 ANVIL
1	1	-	-	-	224908-1 CRIMPER, WIRE (NOSE)
1	1	-	-	-	224907-1 CRIMPER, STABILIZER
1	1	1	1	1	5-22280-0 SPRING, SHEAR
1	1	1	1	1	690461-7 STOP, SHEAR
1	1	1	1	1	1-690459-0 HOLDER, SHEAR (FRONT)
1	1	1	1	1	454276-5 SHEAR, FLOAT (FRONT)
-	-	1	1	1	8-854014-8 ANVIL
-	-	1	1	1	4-456408-4 CRIMPER, WIRE (NOSE)
1	1	1	1	1	2-455889-1 DEPRESSOR, SHEAR (FRONT)
1	1	1	1	1	238011-8 SPACER, BLOCK CRIMPER
1	1	1	1	1	4-683454-2 CRIMPER, INSULATION
1	1	1	1	1	455888-6 SPACER, CRIMPER
-	-	1	1	1	815664-2 CRIMPER, STABILIZER
-5	-4	-3	-2	-1	U/M DWG SIZE

QTY	REQD	PER	ASSY	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	PARTS LIST
-	-	-	-	-	DIMENSIONS IN INCHES. DO NOT SCALE PRINT.
-	-	-	-	-	TOLERANCES UNLESS OTHERWISE SPECIFIED:
-	-	-	-	-	2 PLC DEC \pm .25
-	-	-	-	-	3 PLC DEC \pm .4
-	-	-	-	-	4 PLC DEC \pm .8
-	-	-	-	-	ANGLES \pm SURF TEXTURE: REMOVE BURRS, BREAK SHARP EDGES R.015 MAX
P	ECR-05-014696	GB	11-09		
N	ECR 05-003644	TE	5-05		
M	ECN 0150-0684-04	TE	5-04		
L1	0150-1507-02	RK	NOV02		
L	ECN 0150-0262-00	TE	4-00		
K	0150-8254-98	TB	1-98		